

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000593**Date Inspected:** 05-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island**CWI Name:** Lujian Bing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Mock-up 114 & 77**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe the welding of the Caltrans Mock-up # 114.00 and Magnetic Particle Testing (MT), for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Caltrans QA Inspector observed ZPMC shop personnel performing Shielded Metal Arc Welding (SMAW) at Mock-up # 114.00 assembly A65 stiffener tack welds at weld joint # 1. Welding was performed by certified welders Guo Dengyun (037997) and Zhang Xiangrong (066763) in accordance to WPS-B-P-2212-TC-U5b. Both welders appeared to be performing proper inter-pass cleaning techniques. The following digital picture below illustrates welding in progress.

American Bridge QC Warren Buehler performed Visual inspection of Mock-up 77.00 D sub assembly MA5 connection plate tack welds # 11, 12, 13, 14, 15, 16, 17 and 18 after grinding. Mr. Buehler requested that tack welds be blended to a smooth transition on the end of tack weld. ZPMC shop personnel flipped sub assembly MA5 to make grinding possible in a horizontal position.

Caltrans QA Inspector observed ZPMC QC nondestructive technician, Mr. Cai Xin Xin perform magnetic particle testing (MT) and visual testing (VT). The testing was performed on Mock-up # 77.00 Skin Plate D sub assembly MA5 connection plate tack welds # 11, 12, 13, 14, 15, 16, 17, and 18. At the conclusion of testing Mr. Cai Xin Xin stated the welds were found acceptable.

The Caltrans QA Inspector performed VT and MT examinations on the connection plate tack welds # 77.00 Skin

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Plate D sub assembly MA5. Caltrans QA Inspector observed that the welds appeared to be in general conformance with AWS D1.5 2002 requirements. See MT report TL6028 generated on this date for further information.



Summary of Conversations:

As Identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Viars, Larry	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
